

Work Order ID 61289

August 13, 2010 10:23:27 AM



Page 1

Item ID: D350-604-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rear Locker Extender

Start Date: 8/13/10 Start Qty: 1.00



Cust Item ID:

Required Date: 8/27/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: CZ Date: 10/8/13 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D350-604-041	A								
DSI9470	A								

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy bluefile and create labels per PPP D350-604-041 CHG002

8/10/13 log

HJ dr BG 10-9-01

110

0.00



Purchasing

Purchasing

PURCHASING

Memo

0.00

Issue P/O: 12405
Description: D350-604-041 Rear locker extender.
Supplier: Delastek.
Certification of Conformity and process sheet from Delastek is required.

4 x 2600-6 Camlock stud - Ship to Delastek B 10115361 CZ

CZ 10/8/13 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61289

August 13, 2010 10:23:27 AM

Page 2

Item ID: D350-604-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Rear Locker Extender

Start Date: 8/13/10 Start Qty: 1.00

Cust Item ID:

Required Date: 8/27/10 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Packaging

Memo

0.00

Packaging

Ensure a copy of Certification of Conformity and process sheet from Delastek is attached.

CZ 10/9/13 (1)

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Check hole locations to template. DT 8824 Check process sheet and audit.

S 10/09/07

(1)

140

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

C 10/9/13 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61289

August 13, 2010 10:23:27 AM

Page 3

Item ID: D350-604-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Rear Locker Extender

Start Date: 8/13/10 Start Qty: 1.00

Cust Item ID:

Required Date: 8/27/10 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8/26/08

⑩

160

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-604-041

Location: _____
PPP Rev: 6

P10/8/8

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/09/08
MK
10-9-8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 13, 2010 10:36:50 AM

Page 1

Work Order ID: 61289

Parent Item: D350-604-041

Parent Item Name: Rear Locker Extender

Start Date: 8/13/10

Required Date: 8/27/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:Q03.12.01 Reformat KJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

2600-6		Purchased	No				Each	44.0000	4	4			
--------	--	-----------	----	--	--	--	------	---------	---	---	--	--	--



Camlock Stud

Location	Loc Qty	Loc Code
----------	---------	----------

ST381	28	
-------	----	--

114238	4	
--------	---	--

114355	4	
--------	---	--

115177	20	
--------	----	--

ST398	16	
-------	----	--

115361	16	
--------	----	--

D2268

Manufactured No

Each 14.0000 1



Decal

Location	Loc Qty	Loc Code
----------	---------	----------

ST010	14	
-------	----	--

57535	4	
-------	---	--

60213	10	
-------	----	--

D2269

Manufactured No

Each 11.0000 1



Decal

Location	Loc Qty	Loc Code
----------	---------	----------

ST010	11	
-------	----	--

57536	5	
-------	---	--

60214	6	
-------	---	--

4 CLD/8/12

1 2

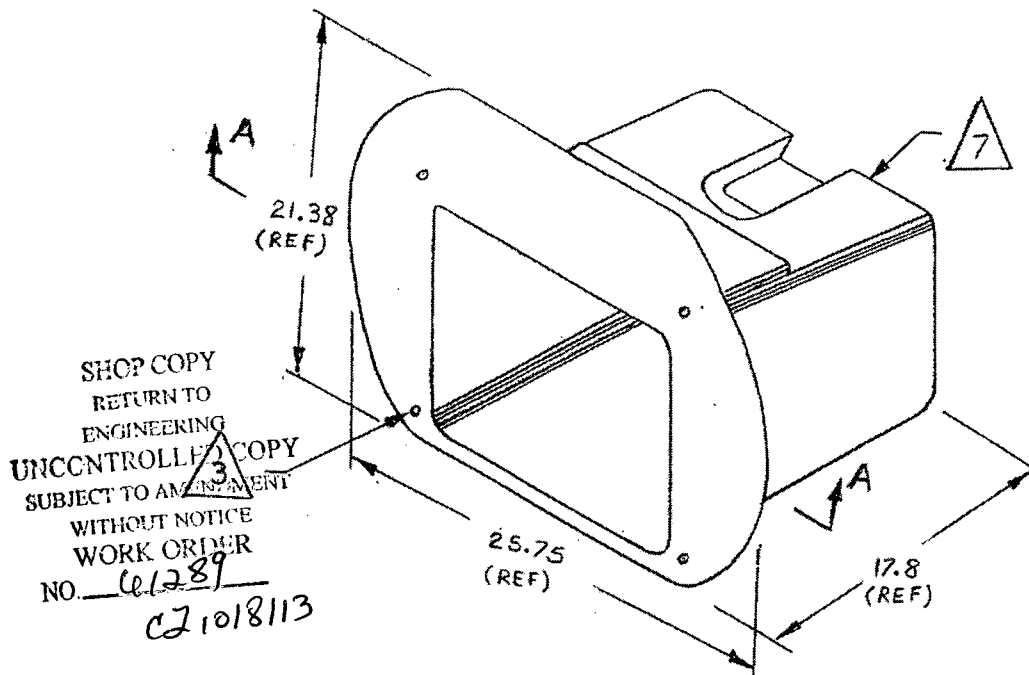
57535

1

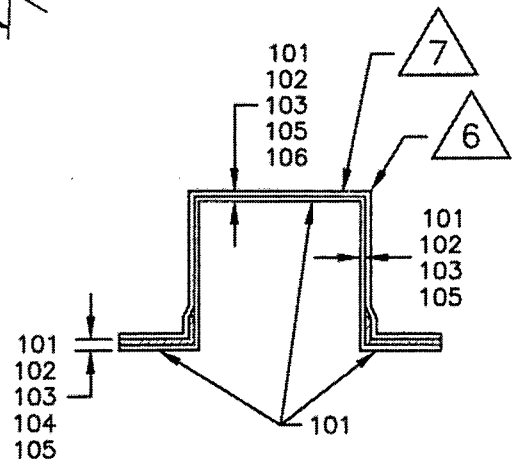
57536

DART

DESIGN	JB	DRAWN BY	DART AEROSPACE LTD
			HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>
DATE	02.04.01	DRAWING NO.	D2273
		REV. D	SHEET 1 OF 1
		TITLE	350 REAR LOCKER EXTENDER
		SCALE	NTS
B	96.05.27	RE-DRAWN	
C	02.01.30	CLARIFY MATERIAL, LAYUP, AND TOOLING	
D	02.04.01	REMOVE EPOCAST, ADD SURFACE FINISH	

RELEASED
02.04.03 *[Signature]***NOTES:**

- 1) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING.
- 2) LAYUP USING DT8010 MOLD. WET LAYUP NO BAG/VACUUM.
- 3) TRIM & DRILL PER DT8020. OPEN HOLES TO $\phi 0.257$ (4 PLACES).
- 4) MATERIALS:
RESIN: DERAKANE 470-36/411/510A40
FIBRE: 9oz = 9.7 oz 7781 WEAVE "S" GLASS
18oz = 18.0 oz ROVING "E" GLASS.
- 5) CONSTRUCTION:
101-WHITE GLOSS GELCOAT # GEL 944W005.
102-9oz ALL OVER.
103-18oz ALL OVER.
104-18oz RE-INFORCE FRONT FLANGE EXTENDING 2" ON SIDES.
105-9oz ALL OVER.
106-PEEL PLY.
- 6) MATTE TO HOLD DOWN CORNERS AS REQUIRED.
- 7) FINISH THIS SURFACE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S.
- 8) ALL DIMENSIONS ARE IN INCHES.

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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-604 REV. B

REF TCCA STC: SH90-4
REF FAA STC: SR00463NY

PURPOSE:

The 2600-4 Camloc Studs may be too short for some installations.

CHANGE:

The qty (4) 2600-4 Camloc Studs are replaced with longer 2600-6 Camloc Studs. It is acceptable to install either 2600-4 or 2600-6 Camloc Studs. The parts list of D350-604 Rev. B is amended as follows:

QTY	PART NUMBER	DESCRIPTION
-041		
X	D350-604-041	REAR CARGO COMPARTMENT EXTENDER ASS'Y

IS:

4	2600-6	CAMLOC STUD
---	--------	-------------

WAS:

4	2600-4	CAMLOC STUD
---	--------	-------------

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WITHOUT NOTICE
WORK ORDER
NO. 61289

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-0-01

APPROVED
BY: [Signature]
D. SHEPHERD (DE # 02)
DATE: 09.07.01
CERT. NO.: SH90-4
ISSUE NO.: 3

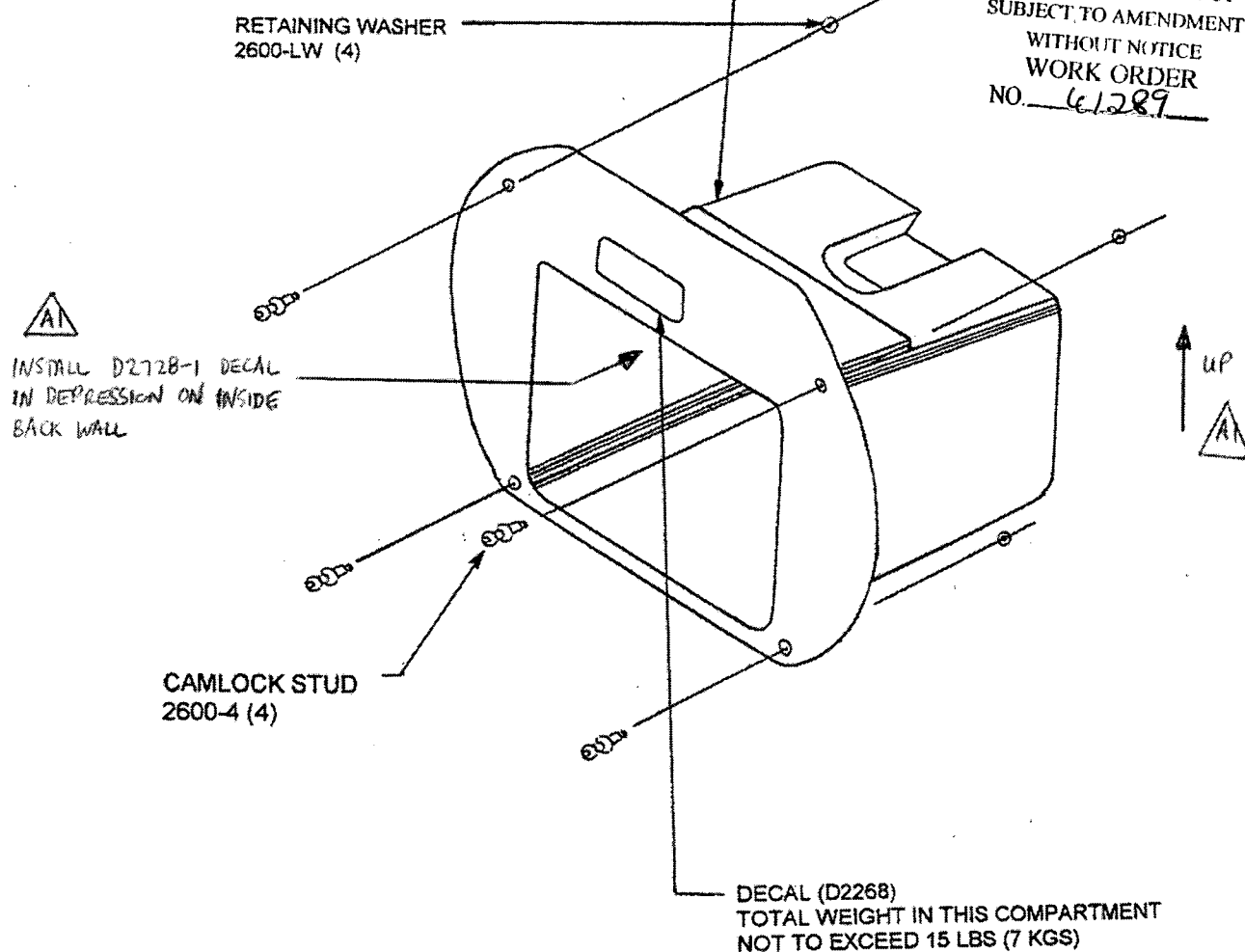
A	NEW ISSUE, NCR 09-046	CP	09.07.01
REV.	DESCRIPTION	BY	DATE
DESIGN	<u>92</u>	DART AEROSPACE LTD	
DRAWN	<u>92</u>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<u>[Signature]</u>	DRAWING NO.	REV. A
MFG. APPR.	<u>VIA</u>	DSI 9470	SHEET 1 OF 1
APPROVED	<u>[Signature]</u>	TITLE	SCALE
DE APPR.	<u>[Signature]</u>	CAMLOC CHANGE	NTS
DATE	09.07.01	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



DESIGN BW	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D350-604-041	REV. A SHEET 1 OF 1
DATE 02.04.01		TITLE REAR LOCKER EXTENDER ASSEMBLY	SCALE NTS
A	02.04.01	NEW ISSUE	
AI	# RF 02.04.23	ADD D2728-1 DECAL & ORIENTATION NOTE REAR LOCKER EXTENDER (D2273)	

RELEASED
02.04.03

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WITHOUT NOTICE
WORK ORDER
NO. 61289



D350-604-041 REAR LOCKER EXTENDER

NOTE: DECALS TO BE ORIENTED TO MATCH 'UP' ORIENTATION OF RLE



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Delastek inc.
2699 5e avenue
Local 14, Porte -A-
Grand-Mère, Québec G9T 5K7
Can ** Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	34564
Customer #	DART US

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Ship to:

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone: 613-632-5200

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
Puro Collect		Origin		Net 30 days USA		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by	Your PO #		GST/PST #	
02/09/2010	13/08/2010	14977	Chantal Lavoie	PO12405			
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0003	Line #1 Rear Locker Extender D350-604-041P B61289 U de M : Each Référence DKA362-0004 DWG: D350-604-041 REV. A1 D2273 REV. D <u>No. série</u> B61289 <u>No. lot</u> 27334			
1	0	1	DKC134-0003	Line #2 Rear Locker Extender D350-604-041P B61290 U de M : Each Référence DKA362-0004 DWG: D350-604-041 REV. A1 D2273 REV. D <u>No. série</u> B61290 <u>No. lot</u> 27872			
1	0	1	DKC134-0003	Line #3 Rear Locker Extender D350-604-041P B61291 U de M : Each Référence DKA362-0004 DWG: D350-604-041 REV. A1 D2273 REV. D <u>No. série</u> B61291 <u>No. lot</u> 27873			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Continued on next page

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

Quality department

AQ-357



Date: Lundi, 2010-06-28 10:36:28
Utilisateur: marc dubé

Feuille de Procédé

Client	: DART US DART AEROSPACE LTD	Nom Dessin	: REAR LOCKER EXTENDER
Numéro Job	: 27334	Numéro Article	: DKC134-0003
Numéro Soumission	: 3482	Numéro Dessin	: D350-604-041 & D2273
Numéro B.A.	:	Projet Numéro	: DK-362
Cette fois	: 2010-06-28 No. B.V. :	Révision dessin	: A & D
Prsht Rev.	: NC	Matériel	: Derakane 470-36/411/510
Prem. fois	: - - Type :	Date Dûe	: 2010-07-05 Qté: 1 Udm: UNITE
Job précédente	: 27333		

Écrit par : _____
Vérifié & Approuvé par : _____
Commentaires : N° de pièce Laminée Dart Aerospace: D2273
N° de pièce Assemblage Dart Aerospace: D350-604-041



B 61289

Process Sheet Rév.: 00 Création du premier à partir de la révision
12 du planning De Delastek Composites

Produit additionnel

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

1.0	AC0085	FREKOTE 3,78L 44-NC
-----	--------	---------------------

Commentair Qty.:	0.02 UNITE(s)/Unit	Total :	0.02 UNITE(s)
------------------	--------------------	---------	---------------

2.0	PRÉPARATION	Préparation du moule
-----	-------------	----------------------



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Nettoyer le moule à l'aide d'un chiffon humide et sécher à l'air. Selon I.F. # DKC134-0003-5.

Note: Afin que le frekote agisse pleinement, le moule doit être libre de toute contamination, enlever tout contaminants à l'aide de Frekote PMC, PMC Plus ou tout autre solvant afficace. Il est permit d'utiliser un abrasif (Doux) afin d'enlever tout accumulation de résine sur le moule.

Appliquer 2 couches de Frekote 44-NC à l'aide du chiffon propre en laissant sécher pendant 15 minutes entre les couches. Le séchage de la dernière couche doit être de 3 heures à température de la pièce avant d'appliquer le Gel Coat.

Date: 9/08/10 Sceau:



3.0	AMB0350	Gel Coat Blanc N° Gel 944W005
-----	---------	-------------------------------

Commentair Qty.:	1.580 UNITE(s)/Unit	Total :	1.580 UNITE(s)
------------------	---------------------	---------	----------------

Gel Coat Blanc N° Gel 944W005

N° de Lot:

1-27878-2

4.0	AMB0286	Catalyst N° DDM-9
-----	---------	-------------------

Commentair Qty.:	0.0070 GALLON(s)/Unit	Total :	0.0070 GALLON(s)
------------------	-----------------------	---------	------------------

Catalyst N° DDM-9

N° de Lot:

1-22176-1

Date: Lundi, 2010-06-28 10:36:28
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 27334

Nom Dessin: REAR LOCKER EXTENDER
Numéro Article: DKC134-0003

Numéro Job:



Séq.:

Machine ou Opération:

Description :

5.0

AC0747

Acetone

Commentair Qty.: 0.200 KILOGRAMME(s)/Unit Total : 0.200 KILOGRAMME(s)

6.0

PREP-GENERAL

Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Faire la préparation du matériel selon I.F. # DKC134-0003-5 :

Dans une quantité de Gel Coat N° 944W005 ajouter 2% de Catalyst N° DDM-9 et diluer à l'aide de 10% D'acétone.

Date: 9/08/10 Sceau:



7.0

GEL COAT

Application du Gel Coat



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs

Selon I.F. 134-0003

À l'aide d'un fusil à gel coat appliquer une couche entre 15 et 20 millièmes de Gel Coat sur le moule N° DKG 362-010 et laisser sécher pendant un minimum de 2 heures avant de faire le lay-up, mais ne pas dépasser 24 heures de séchage selon l'instruction de travail N° Tec-70.

Note: Le gel coat ne doit contenir aucun "airdry" ni aucune cire. Et le temp de séchage est important afin d'éviter d'avoir des défauts de surface, et afin d'éviter que le tissu ne vienne marquer au travers du Gel Coat ainsi que d'éviter d'avoir un rétrécissement.

Autocontrôle de fabrication. (Visuel du Gel Coat)

Date: 9/08/10 Sceau:



8.0

AMB0212

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 1.680 LITRE(s)/Unit Total : 1.680 LITRE(s)

Résine (411B7530) 411-350 promo. 75min

N° de Lot:

1-27817-1 et 1-28040-1

9.0

AMB0286

Catalyst N° DDM-9

Commentair Qty.: 0.0070 GALLON(s)/Unit Total : 0.0070 GALLON(s)

Catalyst N° DDM-9

N° de Lot:

1-22176-1

10.0

AMB0214

9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

Commentair Qty.: 4.6 VERGE(s)/Unit Total : 4.6 VERGE(s)

9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

N° de Lot: 1-26697-1

Date: Lundi, 2010-06-28 10:36:28
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: REAR LOCKER EXTENDER

Numéro Job: 27334

Numéro Article: DKC134-0003

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

11.0	AMB0213	WR1850 Roving 18oz. x 50"
------	---------	---------------------------

Commentair Qty.: 1.140 KILOGRAMME(s)/Unit Total : 1.140 KILOGRAMME(s)
WR1850 Roving 18oz. x 50" N° de Lot: 1-22302-1

12.0	PREP-GENERAL	Préparation du matériel
------	--------------	-------------------------



Commentair Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs

Tailler le matériel selon les dimensions requises à l'aide de gabarit de trimage prévus à cet effet.

Autocontrôle de fabrication. (Selon gabarits)

Date: 30 AVRIL 10 Sceau:

13.0	LAMINAGE	Faire le laminage
------	----------	-------------------



Commentair Setup: 0.00Hrs/ Run: 3.5000Hrs Total Run : 3.5000Hrs

Selon I.F. 134-0003

S'assurer de ne pas trapper d'air entre les rangs

Inscrire les informations suivantes:

Humidité: 48% Température: 18.8 Heure:

Date: 9/08/10 Sceau:

14.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.
------	---------	---

Commentair Qty.: 0.150 LITRE(s)/Unit Total : 0.150 LITRE(s)

Résine (411B7530) 411-350 promo. 75min

N° de Lot: ~~1-22176-1~~ 1-28040-1

15.0	AMB0286	Catalyst N° DDM-9
------	---------	-------------------

Commentair Qty.: 0.0070 GALLON(s)/Unit Total : 0.0070 GALLON(s)

Catalyst N° DDM-9

N° de Lot: ~~1-28040-1~~

1-221-76-1

16.0	FINITION	Finition Générale
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Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Injecter les bulles d'air selon I.F.# DKC134-0003-5.

Date: 9 août 10 Sceau:

Date: Lundi, 2010-06-28 10:36:29
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD		Nom Dessin: REAR LOCKER EXTENDER	
Numéro Job: 27334		Numéro Article: DKC134-0003	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
17.0	DÉMOULAGE	Démoulage de la pièce	
			
Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs			
Selon I.F.# DKC134-0003-5.			
Faire le démoulage de la pièce en poussant de l'air à l'intérieur tout en faisant bien attention de ne pas l'endommager .			
Autocontrôle de fabrication.(Visuel)			
Date: <u>10/08/10</u> Sceau: 			
18.0	TRIMAGE	Trimage / Rivetage	
			
Commentair Setup: 0.00Hrs/ Run: 40.0000Min Total Run : 0.6667Hrs			
Selon I.F.134-0002			
Autocontrôle de fabrication.(Visuel et dimensionel selon le dessin)			
Date: <u>10/08/10</u> Sceau: 			
19.0	AAC1021	Dupont Primer N° 7704S	
Commentair Qty.: 0.3400 UNITE(s)/Unit Total : 0.3400 UNITE(s)			
Dupont Primer N° 7704S N° de Lot: <u>1-26804-3</u>			
20.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase	
Commentair Qty.: 0.0670 UNITE(s)/Unit Total : 0.0670 UNITE(s)			
N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: <u>2-22790-3</u>			
21.0	PRIMER	Application primer	
			
Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs			
Appliquer le primer selon I.G. 0008			
Date: <u>30/08/10</u> Sceau: 			
22.0	AAC1607	Camlock Stud 2600-4 (or Monadnock 1126000-4)	
Commentair Qty.: 4 UNITE(s)/Unit Total : 4 UNITE(s)			
Camlock Stud 2600-4 (or Monadnock 1126000-4) N° de Lot: <u>1-6687-1 1-27798-1</u>			

Date: Lundi, 2010-06-28 10:36:29
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 27334

Nom Dessin: REAR LOCKER EXTENDER
Numéro Article: DKC134-0003

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
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23.0	AAC0682	Washer 2600-LW (1127700)
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Commentair Qty.: 4 UNITE(s)/Unit Total : 4 UNITE(s)
Washer 2600-LW (1127700) N° de Lot: 1-6667-1

24.0	ASSEMBLAGE	Assemblage mécanique
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Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Selon I.F. 134-0004

Démasquer la pièce.

Assembler les quatre (4) Camlock Stud N° 2600-4 à l'aide des Lock Washer N° 2600-LW. Selon l'instruction de travail N° I.G.#Pose de stud.

Autocontrôle de l'assemblage (Visuel)

Date: 31/08/10 Sceau:



25.0	IDENTIFICATION	Identification à encre indélébile
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Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Selon I.F. 134-0005

Faire l'identification de la pièce: N° de pièce D350-604-041

N° de Work Order: _____

L'identification doit être vers l'extérieur.

Date: 31-8-10 Sceau:



26.0	INSPEC FINAL	Inspection finale
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Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire l'inspection dimensionnelle et visuelle de la pièce selon le dessin.

Date: 1 Sept. 10 Sceau:



27.0	EMBALLAGE	Emballage & Entreposage
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Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire l'emballage de la pièce dans le contenant approprié.

Date: Lundi, 2010-06-28 10:36:29
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 27334

Nom Dessin: REAR LOCKER EXTENDER
Numéro Article: DKC134-0003

Numéro Job:



Séq.:

Machine ou Opération:

Description :

Date: 2-9-2010 Sceau:

